

## **IN THE CLAIMS**

Claims 1-98 were previously cancelled. Claims 99, 102-104, 107, 108, 110 and 112-116 are currently amended. Claims 105 and 111 are currently cancelled. Claims 100, 101, 106 and 109 are carried forward, all as follows.

Claims 1-98 (Cancelled)

99. (Currently Amended) A method for supplying paper rolls to a web-fed rotary printing press including:

providing a paper roll supply system for said web-fed rotary printing press;

~~having at least a first subsystem embodied as a~~ providing a paper roll storage facility in said paper roll supply system;

~~providing and having at least a second subsystem embodied as a~~ paper roll transport system in said paper roll supply system;

providing a material flow system for said web-fed rotary printing press~~having a planning level and a coordination level;~~

providing a coordination level in said web-fed rotary printing press material flow system and being in communication with said paper roll storage system;

providing a planning level in said web-fed rotary printing press material flow system and being in communication with said coordination level;

~~using said coordination level of said material flow system for controlling at least said roll transport system and for~~

receiving stock data regarding paper rolls available from said paper roll storage facility in said coordination level of said material flow system;

providing a product planning system for said web-fed rotary printing press and  
having production-relevant planning data regarding pending and planned productions of said  
web-fed rotary printing press;

providing a press management system having actual production data for-in said  
web-fed rotary printing press-machine;

transmitting said actual production data for said web-fed rotary printing press  
from said press management system, said stock data from said coordination level and said  
planning data from said product planning system to said planning level of said material flow  
system;

developing a supply strategy, for use of said paper rolls stored in said roll storage  
facility, in said planning level of said material flow system using said actual production data from  
said press management system, said planning data from said product planning system and said  
stock data from said coordination level; and

using said supply strategy developed in said planning level for instructing said  
coordination level for preparing said paper rolls in~~supplying rolls to said web-fed rotary printing~~  
~~press from~~ said paper roll storage facility of said roll supply system for use in said web-fed  
rotary printing press; and

using said paper roll transport system for supplying said paper rolls prepared in  
said paper roll storage facility in accordance with said supply strategy developed in said  
planning level to said web-fed rotary printing press.

100. (Previously Presented) The method of claim 99 further including providing a press  
management level in said product planning system and further including a fixed signal  
connection for transmitting data between said press management level and said material flow  
system.

101. (Previously Presented) The method of claim 99 including providing at least one fixed signal connection between said product planning system and said material flow system and transmitting data using said at least one fixed signal connection.

102. (Currently Amended) The method of claim 99 further including providing a data network connecting said paper roll supply system, said material flow system and said product planning system of said web-fed rotary printing press.

103. (Currently Amended) The method of claim 99 further including transmitting data between at least one of said paper roll storage facility and said paper roll transport system~~-subsystems~~ of said paper roll supply system and said material flow system and using said data transmitted to said material flow system for controlling said at least one of said paper roll storage facility and said paper roll transport system~~-subsystem~~ of said roll supply system.

104. (Currently Amended) The method of claim 102 further including using said data network for transmitting data from said web-fed rotary printing press and said product planning system to said material flow system and for transmitting data from said material flow system to at least one of said paper roll storage facility and said paper roll transport system~~-subsystems~~ in said roll supply system.

105. (Cancelled)

106. (Previously Presented) The method of claim 99 further including transmitting at least one of an identification of a product, a roll circumference, a time and a location of use of a planned product to said material supply system.

107. (Currently Amended) The method of claim 99 further including transmitting information regarding actual status of a running production of said web-fed rotary printing press as said actual production ~~[[-]]relevant planning~~ data.

108. (Currently Amended) The method of claim 107 further including transmitting identification of said running production and an assignment of said running production to a roll changer ~~change~~ of said web-fed rotary printing press.

109. (Previously Presented) The method of claim 99 including providing at least one roll changer in said web-fed rotary printing press and transmitting roll transport data between said material flow system and said at least one roll changer using at least one fixed signal connection.

110. (Currently Amended) The method of claim 109 further including providing a ~~management level~~ signal connection between said paper roll supply system and said product planning system different from said at least one fixed signal connection.

111. (Cancelled)

112. (Currently Amended) The method of claim 99 further including using said production-relevant planning data in said material flow system and determining a consumption amount.

113. (Currently Amended) The method of claim 99 further including storing said paper rolls in said paper roll storage facility and monitoring said stored paper rolls in said material flow system.

114. (Currently Amended) The method of claim 99 further including providing a flow control of said paper roll storage facility and said paper roll transport system~~-at least first and second subsystems~~ in said paper roll supply system using said material flow system.

115. (Currently Amended) The method of claim 99 further including providing transport orders to said paper roll storage facility and to said paper roll transport system~~-at least first and second subsystems~~ of said paper roll supply system in said material flow system.

116. (Currently Amended) The method of claim 99 further including providing movement control and storage space management of said paper roll storage facility and said paper roll transport system~~-at least first and second subsystems~~ of said paper roll supply system in said material flow system.